

Date: Friday, 13/06/2008 10:47:39 AM
User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	STEP SPACER		
Job Number	39861A			Part Number	D30651		
Estimate Number	10375			Drawing Number	D3065 REV. B		
P.O. Number				Project Number	N/A		
This Issue	13/06/2008	S.O. No.	:	Drawing Revision	B		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	SMALL /MED FAB	Due Date	30/06/2008	Qty:	100 Um: Each
Previous Run	38650A						
Written By							
Checked & Approved By	<u>JW 08.6.13</u>						
Comment	Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est:D 06.04.25 Water jet EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
		Comment: Qty.: 0.1300 sf(s)/Unit Total : 12.9990 sf(s) <i>formed @ CFI</i> Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: _____
2.0	WATER JET	FLOW WATER JET
		<i>issue P10: 6563 GFF cut & formed as per drawing D3065 rev. B</i>
		Comment: FLOW WATER JET 1-Cut as per Dwg D3065 Dwg Rev: _____ Prog Rev: _____ 2-Deburr as required
3.0	QC1	INSPECT PARTS AS THEY COME OFF MACHINE <i>Received + inspect for transit damage ensure crs attached</i>
		<i>1/14 (100)</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC2	SECOND CHECK
		<i>8/10/08 (100) wanted</i>
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		<i>1/4 8/10/08 (100)</i>
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP SPACER

Job Number: 39861A

Part Number: D30651

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

Done at GTF2

7.0 QC5

INSPECT WORK TO CURRENT STEP



u/r see step # 4.0



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(100)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-07-07

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

XCC

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

(P)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 8/07/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

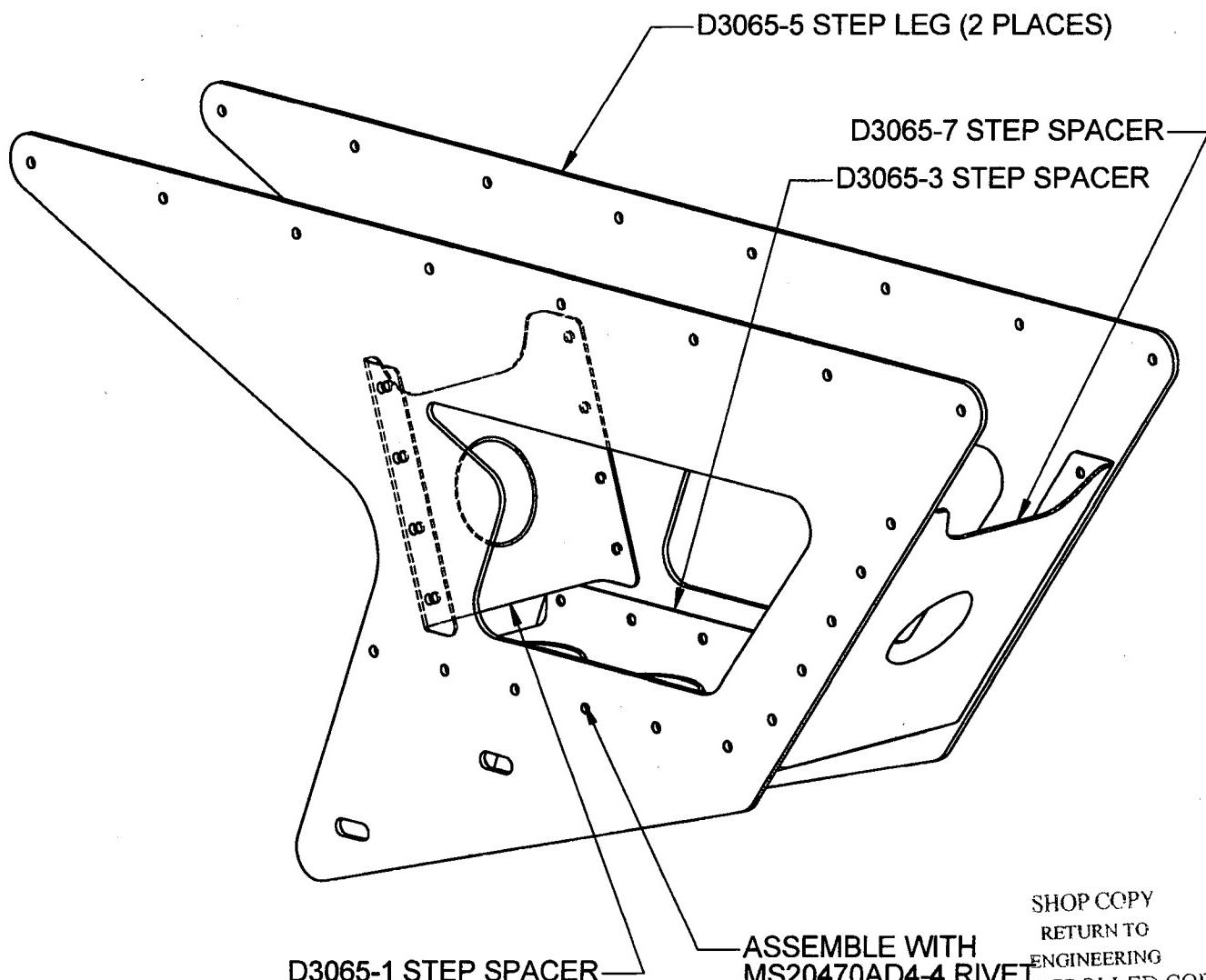
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED*06.06.20 [Signature]*

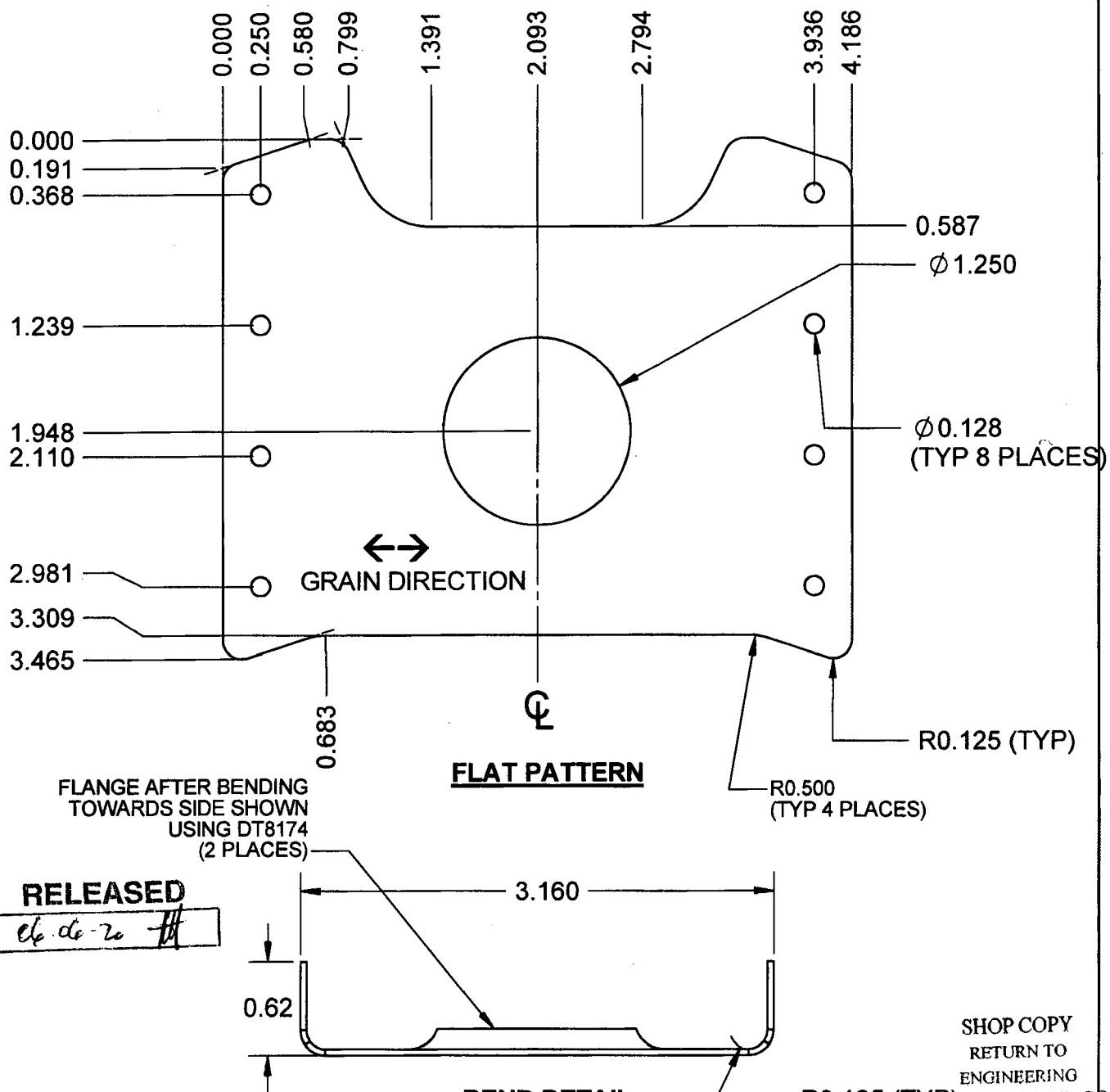
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WORK ORDER
NO. *398014*

D3065-041 STEP LEG ASSEMBLY**COPYRIGHT © 2002 BY DART AEROSPACE LTD.**

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DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

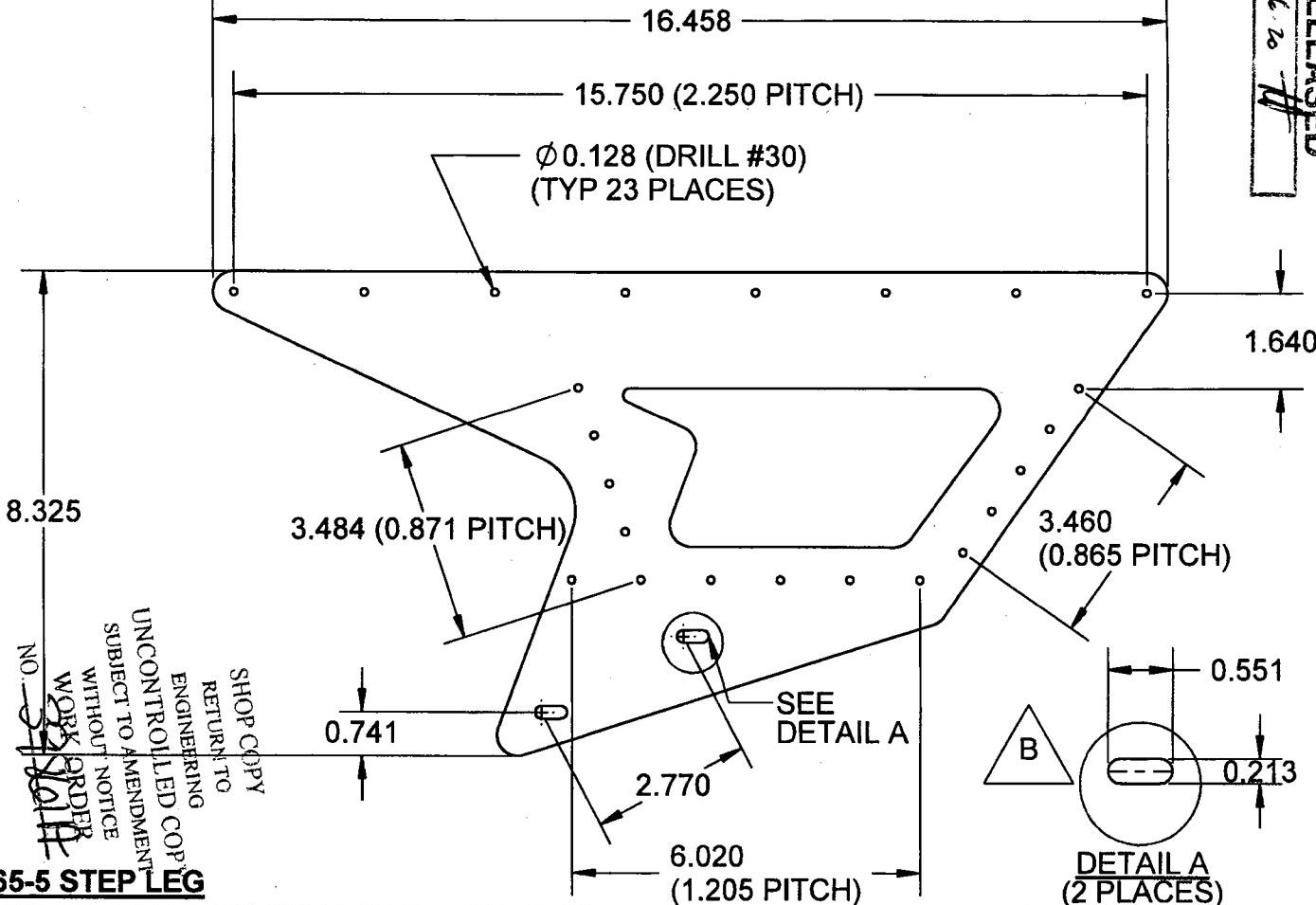
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DART

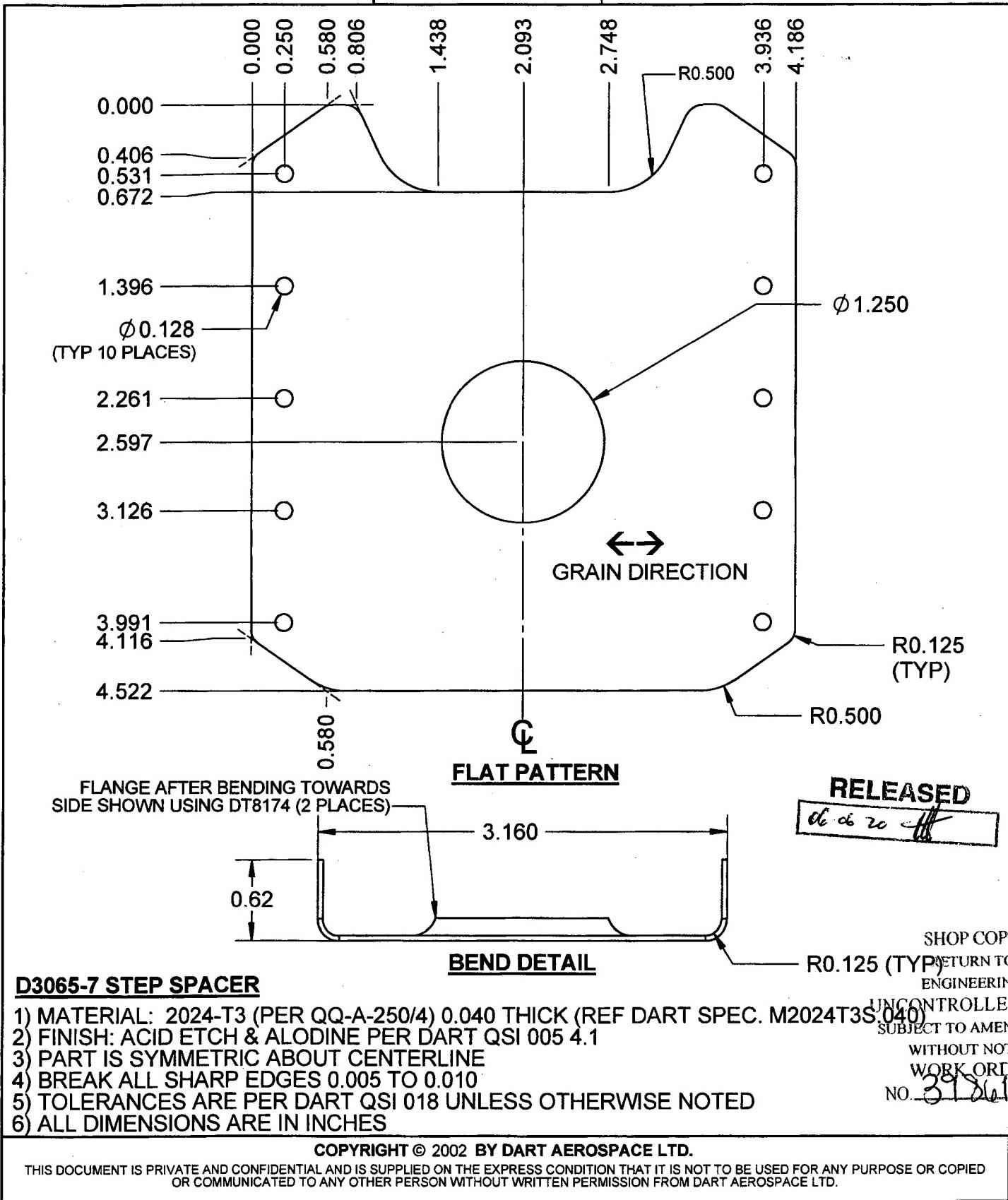
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	D3065
06.05.23	TITLE	STEP LEG ASSEMBLY
	SHEET 4 OF	5
	REV. B	
	SCALE	1:3

RELEASED
06.06.20 *[Signature]*

- D3065-5 STEP LEG**
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
 - 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
 - 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 6) ALL DIMENSIONS ARE IN INCHES

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1





180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

C'est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2008/07/02	0397188

• VENDU À / SOLD TO

ART AEROSPACE LTD
270 ABERDEEN ST.
AWKESBURY, ON, K6A 1K7

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	VIA SHIP VIA
DART GFI-0299	J0185126	P000006563	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION	
100	D30651	STEP SPACER	<i>S 08/02/07</i>

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

REÇU PAR / RECEIVED BY



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITÉ

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

CERTIFICATE NO. 3 OUR JOB NO.

3

OUR JOB NO

J0185126

SHIPPING MEMO

0397188

ITEM QUANTITY PURCHASE ORDER PART NUMBER REV NAME DWG ISSUE

MATERIAL **SUPPLIED BY** **MAT. REL. NO.**
AL 2024-T3 (QQ-A-250/4) **SAMUEL / KAISER ALUMINUM** **H/N # 411944A2**

PROCESS	PROCESSOR	RELEASE NOTE #
1 FIRST ARTICLE INSPECTION REPORT ON FILE	2 GFI	3 CONFORMS
4	5	6
7	8	9

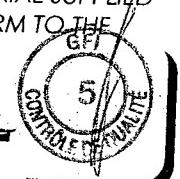
WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED
ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE
DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE

02 JULY 2008

G.F.I. Q.C. REP.

R. Sonnen





Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTER DE CONFORMITÉ – LETTER OF COMPLIANCE

Date: 18 JUIN 2008

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 73751
Customer's order #:

de commande SSMQ: 881160
SSMO's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Bien à vous,
Yours truly,



Maria Griffiths

Commis à l'administration. Administration Clerk.

SHIP TO:

SAMUEL MISSISSAUGA
2360 DIXIE ROAD
MISSISSAUGA, ON, CA L4Y1Z7

BOLD TO:

SAMUEL LAVAL
2225 FRANCIS HUGHES
LAVAL, PQ, CA H7S1N5

KAISER
ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4112280

BL 101120

CUSTOMER PO NUMBER:		WORK PACKAGE:		CUSTOMER PART NUMBER:		SHIP RUN/LOAD ID:	GOVT CONTRACT NUMBER:
N20349						101120/8	
KAISER ORDER NO:	LINE ITEM:	SHIP DATE:	ALLOY:	CLAD:	TEMPER:	PRODUCT DESCRIPTION:	
1058202	2	1-NOV-2007	2024	BARE	T3	MILL FINISH_COIL	
WEIGHT SHIPPED:	QUANTITY:	INV NUMBER:	Gauge:	Width:	Length:		
4442 LB	1 PCS EST.	2015028	0.0400 IN	48.000 IN	0.000 IN		

Certified Specifications

AMS 4037/RevN
CMMP 019/RevD

AMS-QQ-A-250/4/RevA
CMMP 025/RevF

ASTM B 209/Rev06

Test Code: 1504

Test Results

Lot: 411944A2 Cast 398

Drop 18

Ingot 2

08/07/07

(ASTM E8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	68.1 : 68.1 (470 : 470)	46.8 : 47.0 (323 : 324)	17.9 : 18.3

(ASTM E1251)

Chemistry:	Si	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.10	0.29	4.5	0.60	1.4	0.02	0.12	0.02	0.01	0.00	TOT 0.04

ALLOY LIMITS

Chemistry:	Si	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.8	0.30	1.2	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.9	0.9	1.8	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder**CERTIFICATION**

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2722. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

Bill Poyner